

5

DART AEROSPACE LTD		Work Order:	18731
Description: Seal		Part Number:	D3117-1
Dwg: D3117 Rev. A		Qty:	500 540
			Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HA	03.01.23	500
2	PG	Issue P/O: <u>2005049</u> D3117-1 Seal as per Dwg D3117 Possible Supplier: VIP Rubber Replace Premier P/N: B45-43000-01 <b>Material release note required</b>	LL	03-01-23	500
3	RG	Receive and inspect for transit damage <b>Ensure material release note is attached</b>	Q	03-02-25	540
4	QC6	Inspect dimensions as per Dwg D3117 and certification attached.	RB	03-02-25	540
5	PG	Issue P/O: <u>2005138</u> Cut Qty 3 sample 12" long of D3117-1 Send for testing to meet vertical burn test per F.A.R. 25.853 Possible testing site: Bodycote Materials Testing Canada Inc. <b>Test report is required</b>	LL	03-01-23	3
6	RG	Attach test report to W/O	Q	03-02-26	
7	ST	Identify and Stock	Q	03-02-26	540
8	AC	Cost / part <u>1.11</u>	HA	03-02-27	540
9	DC	Close W/O <u>1.11</u> Inspect Level 21	HA	03.02.27	-

Rev	Date	Change	Revised By	Approved
A	03.01.22	New issue	KJ/RF	HA

RELEASED  
03.01.23

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
03.01.29	3	RECEIVED 10ft SAMPLE DIMENSIONALLY OK. SEND. 3 12" SAMPLES FOR BURN TESTING.	W	03.01.29	3	<del>W</del> 03.01.28	<del>W</del> 03.02.29

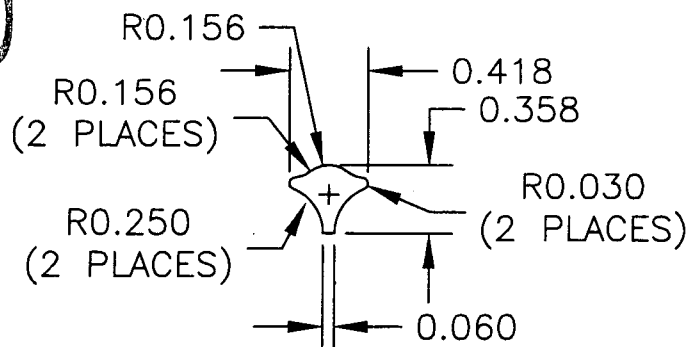
NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3117	REV. A SHEET 1 OF 1
DATE 02.04.15		TITLE SEAL	SCALE 1:1
A	02.04.15	NEW ISSUE	

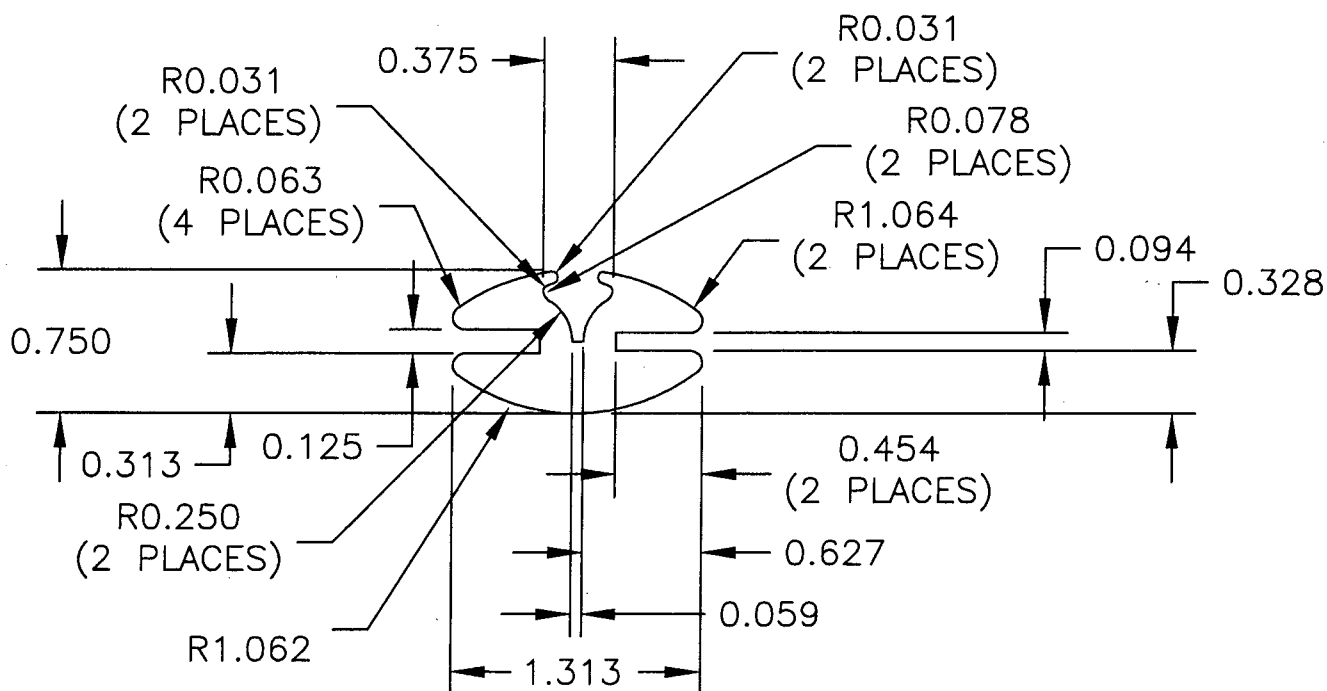
RELEASED  
02.05.27



**D3117-3-XXXX SEAL FILLER**  
REPLACES PREMIER P/N B45-43000-03

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 18731



**D3117-1-XXXX SEAL RETAINER**  
REPLACES PREMIER P/N B45-43000-01

#### NOTES

- 1) MUST MEET BURN TEST PER F.A.R. 25.853
- 2) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100; 87.5" LONG = -0875)
- 3) MATERIAL: BLACK RUBBER 60 DUROMETER (HARDNESS) NEOPRENE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 23, 2003  
11:13 am

Work Order No : 0018731  
Project Name : D3117-1  
Project For : WK305  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3117-1  
Description : Seal Retainer  
Manufactured : Yes  
Amount Req'd : 500  
Amount Done : 0  
Start Date : 01-23-03  
Est Finish Date : 01-30-03  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Blue Rider  
EXTRUDED AND MOLDED RUBBER • EXTRUDED PLASTIC  
540 S. CYPRESS STREET, LA HABRA, CA 90631  
(310) 905-3456 • (800) 722-4VIP  
Fax: (310) 905-3460

CERTIFICATION  
OF COMPLIANCE

3626  
ITEM NO

RE-7107-1897-0156

CUSTOMER PO

2005069

DATE

1-7-03

SHIPPER NO.

19978

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY ONTARIO, CANADA  
K6A1K7 613-632-9577

#1827

PART NO/DESCRIPTION

QUANTITY  
ORDERED

MANUFACTURED IN CONFORMANCE WITH:

P/N B45-43000-01 REV. A SEAL RETAINER  
P/N B45-43000-03 REV. A SEAL FILLER

500 FT.

500 FT.

CURE DATE

1003

SPECIFICATION

50/NEOPRENE MEETS F.A.R. 25.853 (P/N B45-43000-01)  
50/NEOPRENE (P/N B45-43000-03)

By

*Martin Perez*

MARTIN PEREZ  
TECHNICAL DIRECTOR

VIP RUBBER COMPANY

DATE SHIPPED

2/24/03

QTY SHIPPED

540'  
540'

**ACCREDITATION** Standards Council of Canada, Registration #1.

**REGISTRATION** ISO 9002-1994, registered by QMI, Registration #001109.

**SPECIFICATIONS OF ORDER**

Determine flame resistance in accordance with FAR 25.853(a), Amendment No. 25-83, Appendix F Part 1, Paragraph (a)(1)(ii), as per your Purchase Order No. 2005138 dated January 22, 2003.

**CAVEAT**

At the time of report issue, no specific aircraft, test program, or Conformity Inspection Record was listed for inclusion in this report. Therefore, the results stated in this test report are limited to the test coupons supplied. However, if it is subsequently confirmed by the regulatory authority that the specimens tested were representative of the end-use product, the test results may be considered for certification purposes.

**IDENTIFICATION** (BMTC sample identification number 03-02-S0065-1)

Material identified as "Seal Retainer, Part Number D3117-1", approximately 12.0" x 1.25" x 0.75" thick.

**TEST RESULTS** **FAR 25.853(a), Appendix F Part 1(a)(1)(ii)**

Vertical Bunsen Burner Test

12 s Flame Exposure Time

Actual component tested.

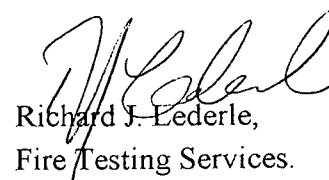
	Burn <u>Length (in)</u>	Flame <u>Time (s)</u>	Drip Flame <u>Time (s)</u>	Results <u>(Pass / Fail)</u>
Test #1	0.1	0.0	0.0	-
Test #2	0.1	0.0	0.0	-
Test #3	<u>0.1</u>	<u>0.0</u>	<u>0.0</u>	-
Average:	0.1	0.0	0.0	-
Specified Maxima:	8.0	15.0	5.0	Pass

**CONCLUSIONS**

The seal retainer identified in this report meets the requirements of FAR 25.853(a), Amendment 25-83.



Anne-Lise Larsen,  
Fire Testing Services.

  
Richard J. Lederle,  
Fire Testing Services.

*Note: This report consists of a cover page, plus 1 additional page that comprise the report "body". It should be considered incomplete if all pages are not present. Additionally, the Appendix of this report comprises a cover page, plus 1 page.*

**ACCREDITATION** Standards Council of Canada, Registration #1.**REGISTRATION** ISO 9002-1994, registered by QMI, Registration #001109.**SPECIFICATIONS OF ORDER**

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**CAVEAT**

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**IDENTIFICATION** (BMTC sample identification number 03-02-S0065-2)

Material identified as "Seal Filler, Part Number D3117-3", approximately 12.0" x 0.30" x 0.35" thick.

**TEST RESULTS** **FAR 25.853(a), Appendix F Part 1(a)(1)(ii)**

Vertical Bunsen Burner Test

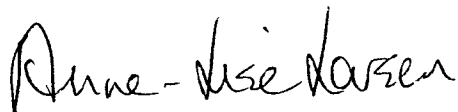
12 s Flame Exposure Time

Actual component tested.

	<u>Burn Length (in)</u>	<u>Flame Time (s)</u>	<u>Drip Flame Time (s)</u>	<u>Results (Pass / Fail)</u>
Test #1	1.1	0.0	0.0	-
Test #2	1.3	0.0	0.0	-
Test #3	<u>1.2</u>	<u>0.0</u>	<u>0.0</u>	-
Average:	1.2	0.0	0.0	-
Specified Maxima:	8.0	15.0	5.0	<div>Pass</div>

**CONCLUSIONS**

The seal filler identified in this report meets the requirements of FAR 25.853(a), Amendment 25-83.



Anne-Lise Larsen,  
Fire Testing Services.



Richard J. Lederle,  
Fire Testing Services.

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